



Dart Aerospace Ltd.
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D4893-2

Job Sheet 183258



Part No: D4893-2

Job Qty: 2 ea

DAS
21
9-89

Part Name: Hard Point Adapter, RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/14/18

Job Tracking No:

Due Date: 10/5/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 13-05-27 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	10/5/18	10/5/18	0.00	0.00	Start Up Machining-3		mm 18/10/12
100	Bandsaw	2 pcs	10/5/18	10/5/18	0.00	0.00	Bandsaw1		"
110	CNC Vertical Machining	2 pcs	10/5/18	10/5/18	3.09	2.44	HAAS1-5		"
130	QC	2 pcs	10/5/18	10/5/18	0.00	0.00	QC8 Machining-3		De 18-10-21
140	HandFinish	2 pcs	10/5/18	10/5/18	0.00	0.14	HandFinish1		BE 18-10-22
150	QC	2 pcs	10/5/18	10/5/18	0.00	0.00	QC7-4		DR 18-10-22
151	Powdercoat	2 pcs	10/5/18	10/5/18	0.00	0.07	Powdercoat1		BE 18-10-22
155	QC	2 pcs	10/5/18	10/5/18	0.00	0.00	QC3		DA OCT 23 2018 68
170	Packaging	2 pcs	10/5/18	10/5/18	0.00	0.00	Packaging3-2		OCT 24 2018 9-89
180	QC21-SA	2 Ea	10/5/18	10/5/18	0.00	0.00	QC21		9-89 OCT 30 2018

Part Op 100 - Cut blank:3.375" long
Descriptions: 110 - 1- Machine as per Folio FB193 and Dwg D4893
151 - MASK AS PER NOTE 9

M188951 START: 1:45
TEMP: 320°
FINISH: 2:15

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B2.000X05.000	6061T6 Bar 2.00 X 5.000	.5800 ft (.29 ea)	90-Start up Operation	503668

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B2.000X05.000	1	9	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Hardpoint Adaptr, RH	72.000Degrees ± 0.500	72.500 71.500	Angle	72
2	Hardpoint Adaptr, RH	1.500Inches ± 0.030	1.530 1.470		1.498
3	Hardpoint Adaptr, RH	0.030Inches ± 0.030	0.060 0.000		0.034
4	Hardpoint Adaptr, RH	45.000Degrees ± 0.500	45.500 44.500	Angle	45.0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval				
Description Work Order Deviation				Disposition							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
				OTHER : ☐							

5	Hardpoint Adaptr, RH	2.450Inches $\pm$ 0.030	2.480 2.420	2.452
6	Hardpoint Adaptr, RH	1.300Inches $\pm$ 0.030	1.330 1.270	1.300
7	Hardpoint Adaptr, RH	0.750Inches $\pm$ 0.030	0.780 0.720	.750
8	Hardpoint Adaptr, RH	2.500Inches $\pm$ 0.005	2.505 2.495	2.501
9	Hardpoint Adaptr, RH	1.250Inches $\pm$ 0.005	1.255 1.245	1.251
10	Hardpoint Adaptr, RH	0.250Inches $\pm$ 0.030	0.280 0.220	Radius .250
11	Hardpoint Adaptr, RH	0.500Inches $\pm$ 0.030	0.530 0.470	.497
12	Hardpoint Adaptr, RH	0.129Inches $\pm$ 0.005 - 0.001	0.134 0.128	Diameter .130
13	Hardpoint Adaptr, RH	0.204Inches $\pm$ 0.005 - 0.001	0.209 0.203	Diameter .207
14	Hardpoint Adaptr, RH	1.500Inches $\pm$ 0.030	1.530 1.470	1.498
15	Hardpoint Adaptr, RH	1.000Inches $\pm$ 0.030	1.030 0.970	1.008
16	Hardpoint Adaptr, RH	1.000Inches $\pm$ 0.030	1.030 0.970	1.004
17	Hardpoint Adaptr, RH	0.130Inches $\pm$ 0.030	0.160 0.100	Radius .125
18	Hardpoint Adaptr, RH	0.830Inches $\pm$ 0.030	0.860 0.800	.845
19	Hardpoint Adaptr, RH	0.100Inches $\pm$ 0.030	0.130 0.070	.105
20	Hardpoint Adaptr, RH	45.000Degrees $\pm$ 0.500	45.500 44.500	Angle 45
21	Hardpoint Adaptr, RH	1.750Inches $\pm$ 0.030	1.780 1.720	1.750
22	Hardpoint Adaptr, RH	1.460Inches $\pm$ 0.030	1.490 1.430	1.450
23	Hardpoint Adaptr, RH	1.650Inches $\pm$ 0.030	1.680 1.620	1.650
24	Hardpoint Adaptr, RH	4.000Inches $\pm$ 0.030	4.030 3.970	4.00
25	Hardpoint Adaptr, RH	0.250Inches $\pm$ 0.030	0.280 0.220	.250
26	Hardpoint Adaptr, RH	45.000Degrees $\pm$ 0.500	45.500 44.500	Angle 45
27	Hardpoint Adaptr, RH	0.750Inches $\pm$ 0.010	0.760 0.740	.750
28	Hardpoint Adaptr, RH	1.015Inches $\pm$ 0.010	1.025 1.005	Diameter 1.022

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Machining ☐ Small Fab ☐ Water Jet ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		DART AEROSPACE Container No: S117943 Part: D4893-2 Job No: 183258 Serial No/Batch: S117943 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 10/12/18					
Description Work Order									
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%; vertical-align: top;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%; vertical-align: top;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%; vertical-align: top;"> Pres ☐ Ben ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:50%; vertical-align: top;"> Setup ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> </tr> </table>				Pres ☐ Ben ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Setup ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐
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